

Specification

ZI I Purpose made metalwork

- 10 **FABRICATION GENERALLY**
- Grades of metals, section dimensions and properties: To the appropriate British Standard and suitable for the purpose.
 - Fasteners: Unless specified otherwise, of same metal as component, with matching coating or finish.
 - Contact between dissimilar metals in components that are to be fixed where moisture may be present or occur: Avoid.
 - Finished components: Rigid and free from distortion, cracks, burrs and sharp arrises.
 - Moving parts: Free moving without binding.
- 11 **FABRICATION: Single leaf**
Posts: 100 x 100 x 6mm x 2800 Long square hollow section 6.3mm thick, with 200mmsq.x 8mm base plate. Cap off ends and weld 100mm Dia. Steel sphere to cap.
Gate: Frame 25x50mmRSH, Verticles 20 Dia solid section, Horizontal flat bar 50x10mm., 3no hinges per gate 20mm diameter
For latch details and drop bolt see Details on drawings
Infill Panel: to match.
- 12 **Double LEAF GATE**
As above.
- 13 **FENCING TYPE A**
Posts: 100 x 100 x 4mm x 2800 Long square hollow section 5mm thick, with 200mmsq.x 8mm base plate. Cap off ends and weld 100mm Dia. Steel sphere to cap.
Frame 25x50mmRSH, Verticles 20Dia hsolid section, Horizontal flat bar 50x10mm.,
- 14 **FENCING TYPE B**
Height to make up difference to 2000mm overall height.
Cranked uprights 80mm.sq.steel posts
- 20 **COLD FORMED WORK**
- Profiles: Accurate, with straight arises.
- 30 **WELDING! BRAZING GENERALLY**
- Surfaces to be joined: Thoroughly cleaned.
 - Tack welds: Use only for temporary attachment.
 - Joints: Made with parent and filler metal fully bonded throughout with no inclusions, holes, porosity or cracks.
 - Surfaces of materials that will be self-finished and visible in completed work: Protect from weld spatter.



- Traces of flux residue, slag and weld spatter Removed.

Specification

40 WELDING OF STEEL

- Preferred method: Metal arc welding to BS EN 1011-1 and -2.
 - Alternative methods: Submit proposals.

50 FINISHING WELDED BRAZED JOINTS VISIBLE IN COMPLETED WORK

- Butt joints: Smooth, and flush with adjacent surfaces.
- Fillet joints: Neatly executed and ground smooth where specified.

60 PREPARATION FOR APPLICATION OF COATINGS

- General: Fabrication complete, and fixing holes drilled before applying coatings.
- Paint, grease, flux, rust, burrs and sharp arrises: Removed.

70A GALVANIZING

- Standard: To BS EN ISO 1461.
- Vent and drain holes: Provide all necessary vent and drain holes. Holes to be located in discreet locations.

100 PAINTING

• PAINTING IN FACTORY:

All galvanised surfaces to be degreased using Dacrylate Thinner 'R5.' The material shall then be treated with Mordant Solution (T wash) 150-23 and then painted without delay with the following system:

Dacrylate Vinidac 41 High Build Mb. ref: 41-line. Apply one coat by brush or spray, as per manufacturers instructions, to an approximate wet film thickness of 190 microns to achieve a dry film thickness of 75 microns. Colour: 41 - 172 (Dark Grey)

Brush application must be carried out with a full wet brush. Do not attempt to brush out or lay off. Ensure sufficient material is applied to achieve specified wet film thickness.

- PAINTING ON SITE:
Dacrylate Vinidac High Build Sheen Top Coat, Ref 41-228 Black, 75 microns dry thickness.
 - Number of coats: One

105 LOCKING SYSTEM

The Alleygating is part of a Master Keyed System the Keys and Locks System Number Bolton F12 SMKS00013



- **Single Leaf Gates: SSP111 Left or Right Handed Metal Locking Case**
- **Single Leaf Gate: DC1 31/31 Ni Euro Double Cylinder**
 - **Double Leaf Gates: Metal Locking Case and DC1 31/31 Ni Euro Double Cylinder**

These Locks and Keys can only be purchased from:

Commsec Ltd
Unit 1
Edwin Rd, Beswick, Manchester, M11 3er

and to be fitted by the Contractor. Tele: 0161 273 8835
<http://www.commsec.co.uk>, email: support@commsec.co.uk

Z20 Fixings/adhesives

10 FIXINGS GENERALLY

- Integrity of supported components: Types, sizes and quantities of fasteners packings and spacings of fixings selected to retain supported components without distortion or loss of support.
- Components substrates fasteners of dissimilar metals: Fixed with isolating washers! sleeves to avoid bimetallic corrosion.
- General usage: To recommendations of fastener manufacturers and or manufacturers of components, products or materials fixed and fixed to.
- Appearance: As approved samples.

25 FASTENER DURABILITY

- Fasteners in external construction:
 - Fasteners not directly exposed to weather Of corrosion resistant material or with a corrosion resistant finish.
 - Fasteners directly exposed to weather of corrosion resistant material.

30 FIXINGS THROUGH FINISHES

- Penetration of fasteners! plugs into substrate: To achieve a secure fixing.

37 SECURITY NUTS

- All nuts used for fixing to be 'Permacone' security nuts. All nuts to be sheared after fix

Specification

D20 Excavating and filling

To be read with Preliminaries/General conditions.

CLEARANCE/EXCAVATING

181A SITE CLEARANCE

- Timing: Before starting work, verify with CA which existing fencing or other site features are to be removed.
- General: Clear site of rubbish, debris and vegetation. Materials arising are to be removed from site.

270 FOUNDATIONS GENERALLY

- Give notice if:
 - A natural bearing formation of undisturbed subsoil is not obtained at the depth shown on the drawings.
 - The formation contains soft or hard spots or highly variable material.

290 FOUNDATIONS IN MADE UP GROUND

- Depth: Excavate down to a natural formation of undisturbed subsoil.
- Discrepancy: Give notice if this is greater or less than depth given.

310 UNSTABLE GROUND

- Generally: Ensure that the excavation remains stable at all times.
- Give notice: Without delay if any newly excavated faces are too unstable to allow earthwork support to be inserted.
- Take action: If instability is likely to affect adjacent structures or roadways, take appropriate emergency action.

330 UNRECORDED FEATURES

- Give notice: If unrecorded foundations, beds, voids, basements, filling, tanks, pipes, cables, drains, manholes, watercourses, ditches, etc. not shown on the drawings are encountered.

MATERIALS

FILLING

710 HARDCORE FILLING

- Fill: Granular material, free from excessive dust, well graded, all pieces less than 75 mm in any direction, minimum 10% fines value of 50 kN when tested in a soaked condition to BS 812-111, and in any one layer only one of the following:
 - Crushed rock (other than argillaceous rock) or quarry waste with not more binding material than is required to help hold the stone together.
 - Crushed concrete, crushed brick or tile, free from plaster, timber and

metal.

- Crushed non-expansive slag.
- Gravel or hoggin with not more clay content than is required to bind the material together, and with no large lumps of clay.
- Well-burned non-plastic colliery shale.
- Natural gravel.
- Natural sand.
- Filling: Spread and level in 150 mm maximum layers. Thoroughly compact each layer.

Specification

715 VENTING HARDCORE LAYER

- Fill: Clean granular material, well graded, passing a 75 mm BS sieve but retained on a 20 mm BS sieve.
In each layer only one of the following:
 - Crushed hard rock.
 - Crushed concrete, crushed brick or tile, free from plaster, timber and metal.
 - Gravel.
- Filling: Spread and level in 150 mm maximum layers. Thoroughly compact each layer whilst maintaining enough voids to allow efficient venting.

730 BLINDING

- Surfaces to receive sheet overlays or concrete:
Blind with:
 - Concrete where shown on drawings; or
 - Sand, fine gravel, or other approved fine material applied to fill interstices.Moisten as necessary before final rolling to provide a flat, closed, smooth surface.
- Sand for blinding: To BS 882 table 4, type C or M, or to BS EN 12620, grade 0/4 or 0/2 (MP).
- Permissible deviations on surface level: +0 -25 mm.